

# Work Order ID 73543

Friday, September 02, 2011 8:53:31 AM



ASAP

Page 1

Item ID: D3436-044

Accept



Setup Start



Revision ID:

Stop



Item Name: Step RH

Start Date: 9/2/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept ~  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3436

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and

Dwg D3436-1 Dwg Rev: A

Qty: Part Number: Description: Batch

A/R: N/A: 4130 Welding Rod M100075

Weld right step D3436-4 using welding Jig DT8773 and Dwg D3436-1 Dwg Rev: A

Qty: Part Number: Description: Batch

A/R: N/A: 4130 Welding Rod M100075

Weld cap D3436-7 as per Dwg D3436-1 Dwg Rev: A

Qty: Part Number: Description: Batch

A/R: N/A: 4130 Welding Rod M100075

EL 11-9-8 (A2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73543

Friday, September 02, 2011 8:53:31 AM

Page 2

Item ID: D3436-044

Accept

Revision ID:

Item Name: Step RH

Start Date: 9/2/2011 Start Qty: 2.00

Required Date: 9/16/2011 Req'd Qty: 2.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

1-Slit part D3436-041 on bandsaw as per Dwg D3436  
2- deburr

0.00

0.00

EL 119-8 (K2)

120



QC

Quality Control

QC9- Inspect visual per QS1004- Fusion Welds

Memo

0.00

0.00

2 0 BE11/09/08

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S 11/09/09

(+2 RM)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73543

Friday, September 02, 2011 8:53:31 AM



Page 3

Item ID: D3436-044

Accept



Setup Start



Revision ID:

Stop



Item Name: Step RH

Start Date: 9/2/2011 Start Qty: 2.00



Required Date: 9/16/2011 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

140

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

\*\*\*Apply black anti-skid paint as per Dwg D3436 and QSI 005 4.4\*\*\*

0.00

OF

2X Ø M-11/09/12

RH

BR 11-9-12

150

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

2RH 11-9-12

155

0.00



Small Fab

Small Fab

Memo

Bond pads per dwg and QSI 015

0.00

9/4/09/12 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73543

Friday, September 02, 2011 8:53:31 AM

Page 4

Item ID: D3436-044

Accept

Revision ID:

Item Name: Step RH

Start Date: 9/2/2011 Start Qty: 2.00

Required Date: 9/16/2011 Req'd Qty: 2.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 192A

0.00

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control



8/10/12

22  
RH

11/9/12 SF2

11/9/13 JD

MF  
11-09-0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Friday, September 02, 2011 8:53:28 AM

Page 1

Work Order ID: 73543

Parent Item: D3436-044

Parent Item Name: Step RH



Start Date: 9/2/2011

Required Date: 9/16/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP A: 05.05.11 New Issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3436-5		Manufactured	No			100	Each	28.0000	4	8			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Bushing

73602x9

Location

Loc Qty

Loc Code

ST

20

46592

20

WA020

8

64065

8

D3436-7		Manufactured	No			100	Each	46.0000	1	2			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Cap

Location

Loc Qty

Loc Code

WA021

46

56836

46

D3436-9		Manufactured	No			100	Each	12.0000	2	4			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Pad

Location

Loc Qty

Loc Code

GA

8

56830

2

69599

6

ST053

4

66567

4



EL ~~11-9-8~~ 11-9-8



EL 11-9-8



~~11-9-8~~ 8/4/09/11

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, September 02, 2011 8:53:28 AM

Page 2

Work Order ID: 73543

Parent Item: D3436-044

Parent Item Name: Step RH



Start Date: 9/2/2011

Required Date: 9/16/2011

Start Qty: 2.00

Required Qty: 2.00

D3436-4 Manufactured No

100 Each

2.0000 1 2



Right Step



*A 11-9-8*

*73545 X2*

Location

Loc Qty

Loc Code

WA021

2

51786

2

D3436-1 Manufactured No

155 Each

44.0000 1 2



Clamp



*EL 11-9-8*

Location

Loc Qty

Loc Code

WA021

44

17679

44

*2*

Friday, September 02, 2011 8:53:28 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

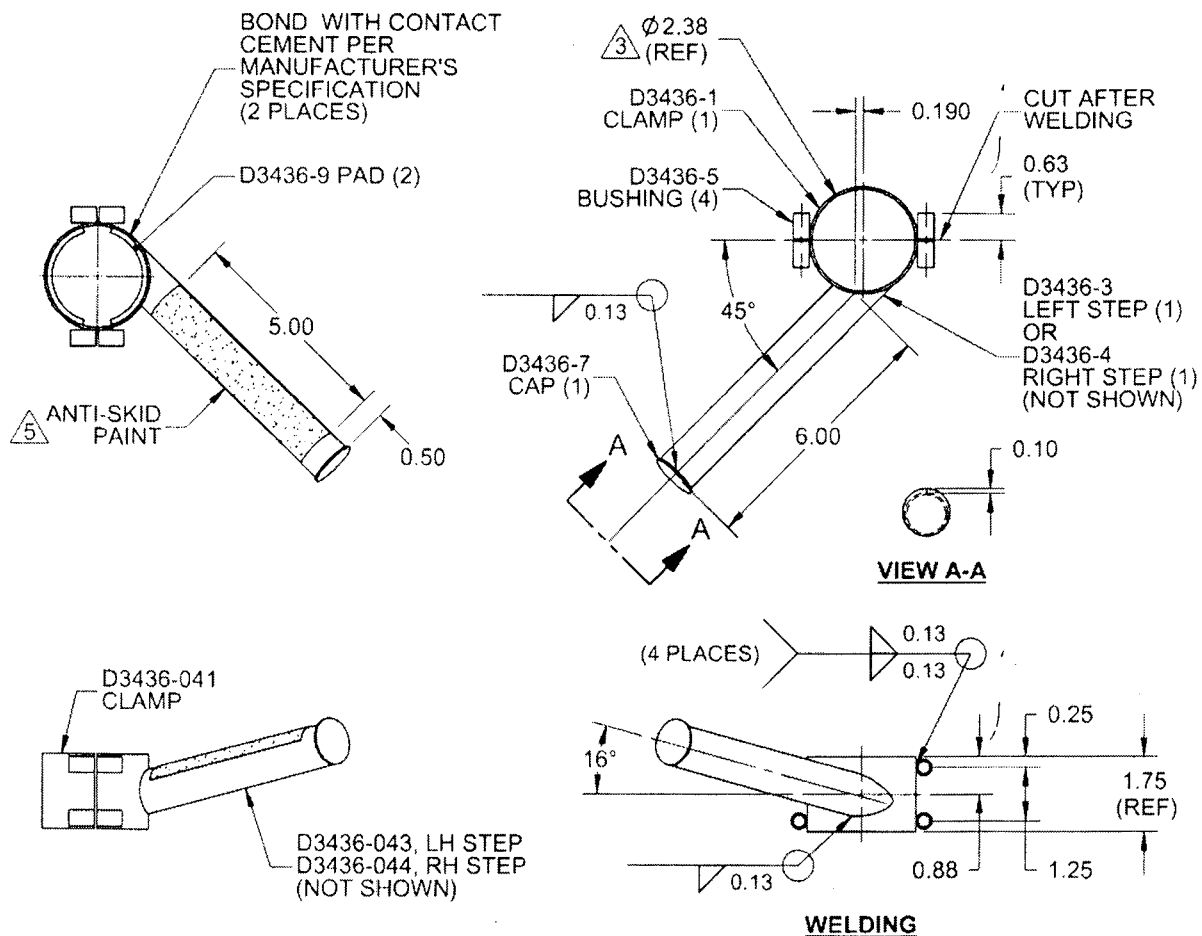
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN MB	DRAWN BY MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. <b>D3436</b>	REV. A SHEET 1 OF 4
DATE <b>05.04.28</b>	TITLE <b>MAINTENANCE STEP</b>		SCALE 1:4
A	05.04.28	NEW ISSUE	



**NOTES:**

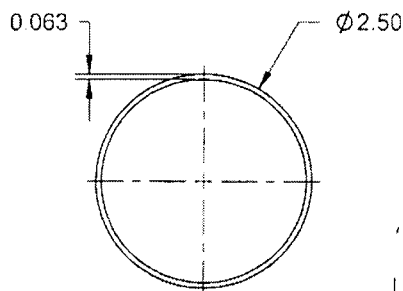
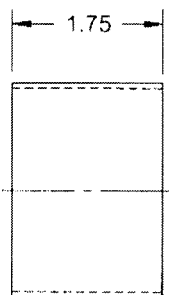
- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

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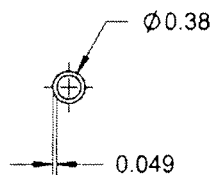
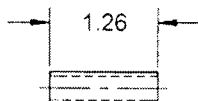


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3436</b>	REV. A SHEET 2 OF 4
DATE <b>05.04.28</b>	TITLE <b>MAINTENANCE STEP</b>		SCALE 1:2



#### **D3436-1 CLAMP**

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



#### **D3436-5 BUSHING**

- 2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

#### **D3436-1/-5, GENERAL NOTES:**

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED  
05-05-27 *[Signature]*

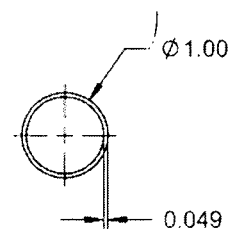
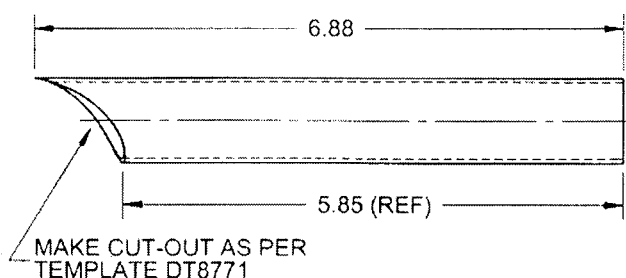
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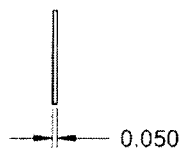
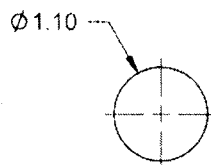
DESIGN MB	DRAWN BY MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3436</b>	REV. A SHEET 3 OF 4
DATE <b>05.04.28</b>	TITLE <b>MAINTENANCE STEP</b>		SCALE 1:2



#### **D3436-3 LEFT STEP**

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



#### **D3436-7 CAP**

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

#### **D3436-3/ -7, GENERAL NOTES:**

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

REVISION  
05-05-27 *[Signature]*

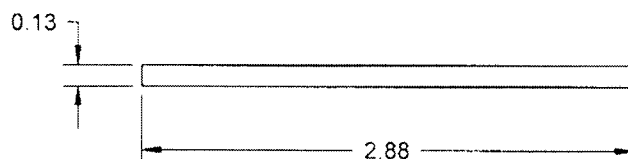
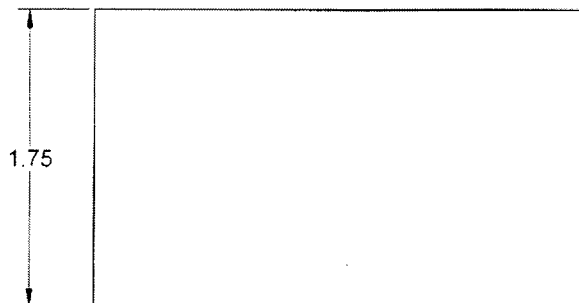
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3436</b>	REV. A SHEET 4 OF 4
DATE <b>05.04.28</b>		TITLE <b>MAINTENANCE STEP</b>	SCALE 1:1



RELEASED  
05-05/27 *[Signature]*

**D3436-9 PAD**

**NOTES:**

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK  
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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